

Work Order ID 163399

Tuesday, June 27, 2017 11:37:27 AM

163399

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Item ID: D4839-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Blade

Start Date: 6/27/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/6/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

DAS

Date: JUN 28 2017

Tooling:

Date:

Run Start

NR1

QC:

21

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4839	REV A

100

0.00

100

Packaging

Memo

0.00

Packaging

PULL FROM STOCK:

8 X 646.9711 B

RE-IDENTIFY AS D4839-1

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.24

Quality Control

120

Identify as per dwg & Stock Location: CCB128

0.00

120

Packaging

Memo

0.08

Packaging

JUL 19 2017

DAS
6
9-89

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Item ID: D4839-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Blade
Start Date: 6/27/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 7/6/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.80							
Quality Control									

DAS
21
2-20

JUL 19 2017

Picklist Print

Tuesday, June 27, 2017 1:51:32 PM

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1

Work Order ID: 163399

163399

Parent Item: D4839-1

D4839-1

Parent Item Name: Blade

Start Date: 6/27/2017

Required Date: 7/6/2017

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9711 *646 9711* Blade		Manufactured	No				Each	0.0000	**	8 161634			

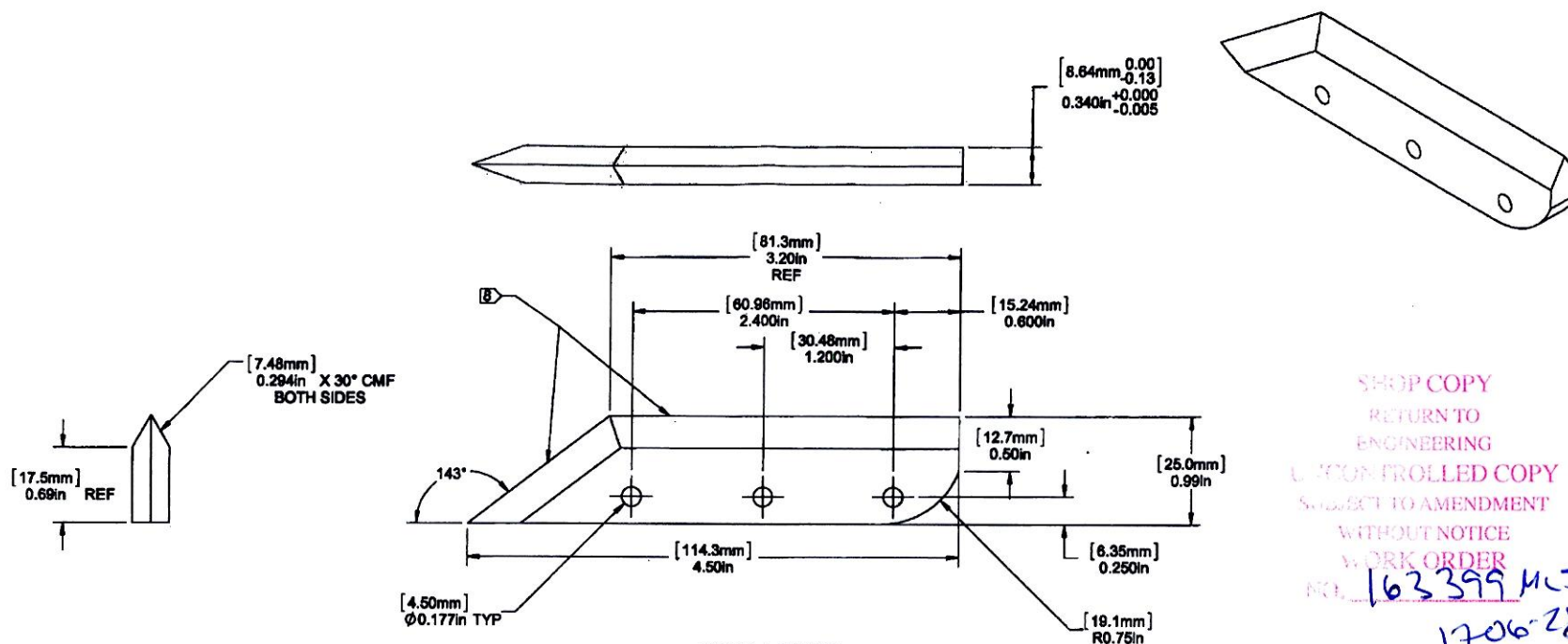
JUL 18 2017
DAS
86

8 7 6 5 4 3 2 1

D

C

B



D4839-1 BLADE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163399 MJS
1706-28

RELEASED
2013-07-12

NOTES:

- 1) MATERIAL: AISI A2 TOOL STEEL PER ASTM A681 (DART SPEC MSTEEL-A2-80.375X4.500)
CONDITION: ANNEALED (HEAT TREAT TO 68-62 ROCKWELL C HARDNESS) PER MIL-T-6736 OR AMS2759/1E
- 2) FINISH: PRIME IAW MIL-P-23377J TYPE1, CLASS N: 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs (0.13 kg)
- 8) DO NOT BREAK EDGE OF BLADE, INTENDED TO BE SHARP
- 9) REFERENCE APICAL PART NUMBER 646.9711

A NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	21	D4839	SHEET 1 OF 1
APPROVED	10	TITLE	SCALE
DE APPR.	10	BLADE	NTS
DATE	13.05.23	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1